

Date: Monday, 10/22/2007 4:00:34 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: SHORT STEP INSTALLATION KIT	
Job Number	35319		Part Number	: K591113	
Estimate Number	10542		Drawing Number	: D350-591 REV F PG17	
P.O. Number	N/A		Project Number	: N/A	
This Issue	10/22/2007	S.O. No.	Type	: SMALL /MED FAB	
Prsht Rev.	NC		Drawing Revision	: F	
First Issue	N/A		Material	: N/A	
Previous Run	31493		Due Date	: 12/10/2007	
Written By			Qty:	12	Um: Each
Checked & Approved By			✓		
Comment	Est: 04.11.09 Reformat KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2171	Clamp	
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description	Batch
2	D2171	Clamp	B 33936

AS 04/12/05 (x2)

2.0	D2182B	Neoprene Cushion-.750 bl	
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Comment: Qty.: 0.5833 f(s)/Unit Total : 6.9996 f(s)

Neoprene Cushion-.750 bl

Pick:

Qty	Part Number	Description	Batch
7"(2 x 3.5")	D2182B	Cushion	B 34777

AS 04/12/05 (x2)

3.0	D2274	Radius Block	
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Radius Block

Pick:

Qty	Part Number	Description	Batch
4	D2274	Radius Block	B 32857

AS 04/12/05 (x2)

4.0	D23623	Step Support Bracket	
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Step Support Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2362-3	Support Bracket	B 31503(x2) B 34292 (x1) B 35328 x9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 35319

Part Number: K591113

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2856400 Abrasion Strip

~~XXX~~



Comment: Qty.: 0.6000 f(s)/Unit Total : 7.2000 f(s)

Abrasion Strip

Pick:

Qty	Part Number	Description	Batch
7.2" (QTY 1)	D2856-400	Abrasion Strip	M34642



6.0 AN337A Bolt

~~XXX~~



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3-37A	Bolt	M104016

AS 07/12/05 X12



7.0 AN420A Bolt

~~XXX~~



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-20A	Bolt	M16895

M16895

AS 07/12/05 X12

8.0 AN422A Bolt

~~XXX~~



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M102959

AS 07/12/04 X12



9.0 AN960JD10 Washer

~~XXX~~



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M105792

AS 07/12/04 X12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/12/11
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 4:00:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 35319

Part Number: K591113

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN960JD416

Washer

~~HTT~~ ~~XXX~~



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	AN960JD416	Washer	<u>M105906</u>

~~HTT~~ ~~XXX~~

11.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	<u>M105558</u>

~~HTT~~ ~~XXX~~

12.0 MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
5	MS21042L4	Nut	<u>M105054</u>

13.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 350A 01/85-211

AS 04/12/07 6

(12)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 04/12/11

(12)

Job Completion



AS 04/12/10

AS 04/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
						D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
				1		D2362-041	SUPPORT BRACKET
2	1				1	D2362-3	SUPPORT BRACKET
				1		D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2			2	AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1			1	AN4-22A	BOLT
4	4	4			4	AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2			2	MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 35319